Final version
Our ref.: JELEN-10002

ABSTRACT OF THE INVENTION

A small hole electrical discharge machining apparatus 1 is comprised of electrode holding 27 means for holding an upper part of an electrode 39, electrode guide means 41 for guiding a lower part of the electrode 39, a jet nozzle 73 injecting a water jet (WJ) from the electrode holding means 27, and a fluid channel 97 which supplies a gas, such as air, to an electrode guide 75 of the electrode guide means.

The electrode 39 is guided with the water jet (WJ) toward the workpiece (W), and small hole electrical discharge machining is performed while the gas is being released from the electrode guide 75 into a working liquid via the fluid channel 97.